

Date: Monday, 25/08/2008 9:56:10 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 41615		
Estimate Number	: 13052		
P.O. Number	:	Part Number	: D36704200
This Issue	: 25/08/2008 S.O. No. :	Drawing Number	: D3670 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 36818	Material	:
Written By	:	Due Date	: 10/09/2008
Checked & Approved By	: <u>JUD 08.8.25</u>	Qty:	200 100 U/m: Each
Comment	: Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w
Comment: Qty.: 0.3675 f(s)/Unit Total : 36.7500 f(s) Material: (M6061T6T0.313W.058) Batch: <u>M107112</u> <u>mmf 08/08/31</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: 1-TURN AS PER FOLIO FA711& DWG D3670 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>mmf 08/08/31</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mmf 08/08/31</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SD 08/09/02</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Barkley</u> <u>JS 08/09/02</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-09-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

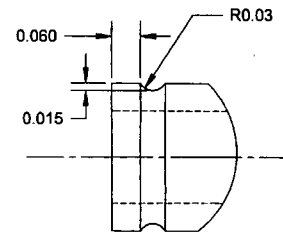
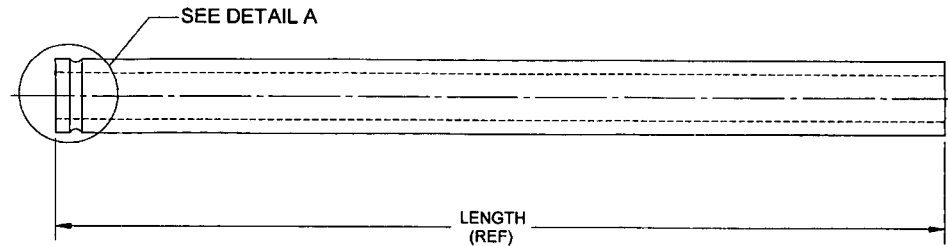
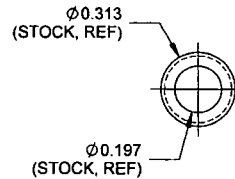
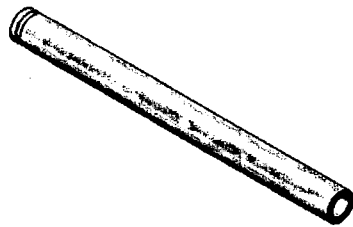
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER

LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07-11-06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M8061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE
WEIGHT: TO BE DETERMINED
RETURN TO: ENGINEERING
HOP COPY
TO AMENDMENT
WORK ORDER

A NEW ISSUE		DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	h		
MFG. APPR.	330		
APPROVED	WJ		
DE APPR.			
DATE	07.10.19		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D3670	REV. A
		TITLE SPACER	SHEET 1 OF 1
		SCALE 2:1	
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